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W	Order ID	100/50
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108650



Revision ID: Revision ID:	Friday, October	25, 2013 1:24:37 PM										
Start Date: 10/25/2013 Start Qty: 40.00 *40* Cust Item ID: Customer: Required Date: 11/15/2013 Req'd Qty: 40.00 *40* Customer: Reference: Run Start *NR1* NR2* Stop *NR2* Stop *NR2* NR2*	Revision ID:		,	Accept	N9 00	040	100)*		IV	• • •	
Approvals: Process Plan: MI	Required Date:					ID:						
Sequence ID Date: SPC (Y/N): Date: Stop *NR 2*	Approvals:	Process Plan: MJ	Date:/3-10-25	Tooling:	D	ate:				!/	R1*	
Nork Center ID		QC:	Date:	SPC (Y/N):					Sto	*N	R2*	
D3216 Rev A					Tool ID	Tool #					•	
#100 #100 #100 #100 #100 #100 #100 #100	Draw Nbr	Revision Nbr										-
#100	D3216	Rev A										
110 QC Quality Control Memo QC8- Inspect parts - second check QC	*100* Waterjet	Memo et 1-Cut as p	per Dwg D3216 Dwg Rev:_ necessary	0.00	2-			54			Jm13.	10-2
Quality Control 120 QC8- Inspect parts - second check *120* QC Memo O.00 DAS 27 9-89 QC Memo O.00 DAS (C) 9		QC2- Inspect parts off	machine FAI/FAIB	0.00				5 <i>u</i>	2		Tm 13:20	n- 21.
120 QC Memo 0.00 B 10 28 SY Co. 4		Memo		0.00				_9_				
$\frac{1}{6}$ Memo $\frac{1}$		QC8- Inspect parts - se	econd check	27				<u></u>	1			
	QC	Memo		8601 & 00.0				Cour	}	<u> </u>		<i>2</i>

		DQA:	Date:	
NCR: Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE			

							•		QA Closed:	Date	2:
Work Orde	er:				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part N					Rework Scrap Use-as-is Work Order Update	The	Skid-tube Machining rmoforming Large Fab	Crosstube Small Fab Finishing Composite	1	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update	Initial	Α	Action	Sign &		
Cause	Dat	e Step	Qty	ı	or Non-conformance	Chief Er	g Des	scription	Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling											
Operator						ļ					
Material	\Box		ì								
Setup						•					
Other											
Process											
Supplier						-					
Training											
Unapproved		<u> </u>		<u> </u>					L		
						AULT CA	regory				
Landi	ng Gear				General				7	r	
	Bend	•			Bend	Grain		·	Ovalized	_	Pressure/Forced
		e Not Conce	ntric to	o/s _	BOM/Route	Hard		<u> </u>	Over/Under	 -	Temperature/Cure
	Crack				Broken/Damaged	—	ction incomplete	-	Part Incorre	⊢	Weld
	⊢ —	ed/Crimped		<u> </u>	Burrs	\blacksquare	ictions Incomplete	e/Unclear	Part Lost/Mi	issing [Wrong Stock Pulled
	Cuffs			_	Contamination	\mathbf{H}	itenance	<u> </u>	Part Moved		
	Heat			<u> </u>	Countersink	\vdash	beled	<u> </u>	Positioned V		¬ ₋.
	_	ction Strip in	Tube	<u> </u>	Cut Too Short	Misre		L	Power Loss/	Surge	Other
	├	es in Bend		-	Drill Holes	Offse					<u> </u>
		e Waves in		n	Drawing	\blacksquare	of Calibration				
	$oldsymbol{oldsymbol{ o}}$	ng Sequence		<u> </u>	Finish	$\boldsymbol{\vdash}$	of Sequence				
	Wave	Wave/Twist in Tube		1	Folio	Outs	de Dimensions				

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order	ID	108650
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108650

Page 2

Friday, October 25, 2013 1:24:37 PM Item ID: D3216-1 Accept *N900040100* Setup Start Revision ID: Item Name: Fitting *40* **Start Qty: 40.00 Start Date:** 10/25/2013 **Cust Item ID: Required Date:** 11/15/2013 Reg'd Oty: 40.00 *40* **Customer:** Reference: Run Date: Approvals: Tooling: Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Reject Tool ID Tool # Plan Reject Accept Insp. Description Work Center ID Qty Qty **Run Hours** Code Number Stamp 130 0.00 Small Fab *120* Small Fab 0.00 Memo Small Fab Tumble until parts have a polished finish. QC5- Inspect part completeness to step on W/O *140* QC Memo Quality Control Identify as per dwg & Stock Location: S+33 0.00 CX13/10/30 54 *150* Packaging 0.00 Memo Packaging

												DQA:	Date	e:		
NCR: Y	'es	/ No					WORK ORDER NON-O	COI	VFORM	MANCE / UP	DATE	QA Closed:	Date	.		
		·	<u> </u>				DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Nork Orde	er:							,				7	, 			
Part N	lo.				· · · · · · · · · · · · · · · · · · ·		Rework Scrap Use-as-is		ı	Skid-tube Machining	Crosstube Small Fab Finishing	_	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other		
NCR N	lo.						Work Order Update				Composite	- Nec/Stol	Supplier	Joune		
Root					Des	crip	otion of work order update	П	nitial	Ac	tion	Sign &				
Cause		Date	Step	Qty		O	r Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector		
oc/Data quip/Tooling perator laterial etup other	Data property propert															
rocess upplier raining																
napproved					Ì											
				<u> </u>			F	AUL	T CATE	GORY		<u> </u>				
Landii	ng (Gear					General									
		Bending					Bend		Grain			Ovalized		Pressure/Forced		
		Centre No	ot Conce	ntric to	O/S		BOM/Route		Hardwa	re	_	Over/Under	tolerance	Temperature/Cure		
		Cracks					Broken/Damaged	L	Inspecti	on Incomplete		Part Incorre		Weld		
	Crushed/Crimped			_	Burrs	L	Instruct	ions Incomplete/	'Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled				
					Contamination		Mainte			Part Moved						
	Heat Treat Countersink					\perp	Mislabe			Positioned V						
	Inspection Strip in Tube Cut Too Short				ł		Misread	i	<u></u>	Power Loss/	Surge	Other				
	L	Ripples in	Bend			$oldsymbol{ol}}}}}}}}}}}}}}}}}}$	Drill Holes		Offset							
		Torque W	/aves in l	Extrusio	n		Drawing		Out of	Calibration						
	Turning Sequence						Finish	Sequence								

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Wave/Twist in Tube

Folio

	er ID 108650 25, 2013 1:24:37 PM		*108650*							Page 3		
Start Date:	D3216-1 Fitting 10/25/2013 Start Qty: 40.00	*40*	Accept	*N900 Cust Item II		100)* s	etup Sta	l	NS1* NS2*		
Required Date: Reference:	11/15/2013 Req'd Qty: 40.00	*40*		Customer:			-					
Approvals:	Process Plan: QC:		Tooling: SPC (Y/N):		te:		R		art * op *	NR1* NR2*		
Sequence ID/ Work Center II 160 *160* QC Quality Control	Operation Description QC21- Final Inspection Memo	- Work Order Release	Set Up/ Run Hours 0.00 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Numl	oer Stamp 3-/0-3		

									DQA:	Date:			
NCR: Ye:	s / No				WORK ORDER NON-C	ONFOR	MANCE / UP		QA Closed:	Date:			
Work Order:					DISPOSITION	:	AGAINST DEPARTMENT/PROCESS						
Part No			.,	· · · · · · · · · · · · · · · · · · ·	Rework Scrap	Skid-tube Crosstube Machining Small Fab			Water Jet d. Eng. Coor.	Engineering Quality			
NCR No					Use-as-is Work Order Update	Iner	moforming Large Fab	Finishing Composite	Rec/Sto	re/Packaging Supplier	Other		
Root				Descri	ption of work order update	Initial	Ad	ction	Sign &				
Cause	Date	Step	Qty	C	or Non-conformance	Chief Eng	Desc	cription	Date	Verification	QC Inspector		
Doc/Data													
Equip/Tooling													
Operator		1			•					,			
Material									:				
Setup			1										
Other													
Process													
Supplier													
Training													
Unapproved	7												

Landing	Gear	General		_		_
	Bending	Bend		Grain	Ovalized	Pressure/Forced
	Centre Not Concentric to O/S	BOM/Route		Hardware	Over/Under tolerance	Temperature/Cure
	Cracks	Broken/Damaged		Inspection Incomplete	Part Incorrect	Weld
	Crushed/Crimped	Burrs		Instructions Incomplete/Unclear	Part Lost/Missing	Wrong Stock Pulled
Γ	Cuffs	Contamination	Г	Maintenance	Part Moved	
	Heat Treat	Countersink		Mislabeled	Positioned Wrong	 _
	Inspection Strip in Tube	Cut Too Short		Misread	Power Loss/Surge	Other
Γ	Ripples in Bend	Drill Holes		Offset		
	Torque Waves in Extrusion	Drawing		Out of Calibration		
	Turning Sequence	Finish		Out of Sequence		
	Wave/Twist in Tube	Folio	Г	Outside Dimensions		

FAULT CATEGORY

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Page 1

Work Order ID:

108650

Parent Item:

D3216-1

Parent Item Name:

Fitting

Start Date: 10/25/2013

Required Date: 11/15/2013

Start Qty: 40.00

Required Qty: 40.00

Comments:

IPP: A03.10.28New IssueKJ/RF

IPP Rev:B Now on Waterjet 06-07-03 JLM

		III KCV.B NOW	on waterjet 00-0	J/-03 JL.	IVI										
•	Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status	
190000	M304S11GA		Purchased	No			100	sf	212.5633	0.0288	(3)		Tn	212 10	-
3	304/316 0.125 Sheet										_			715-10 -	- 0

<u>Location</u>	Loc Qty	Loc Code
MAT020	212.5632632	
122521	19.1432632	
124445	43.5	
M126075	149.92	

126075

		DQA:	Date:	
ICR: Ves / No	WORK ORDER NON-CONFORMANCE / LIPDATE			

Yes / No QA Closed: Date: **AGAINST DEPARTMENT/PROCESS** DISPOSITION Work Order: Skid-tube Crosstube Water Jet Engineering Rework Quality Machining Prod. Eng. Coor. Part No. Small Fab Scrap Thermoforming Finishing Rec/Store/Packaging Other Use-as-is NCR No. Work Order Update Large Fab Composite Supplier Description of work order update Sign & Initial Action Root Qty Chief Eng Description Date Verification QC Inspector or Non-conformance Cause Date Step Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved **FAULT CATEGORY Landing Gear** General Pressure/Forced Bending Bend Grain Ovalized Temperature/Cure Over/Under tolerance Centre Not Concentric to O/S BOM/Route Hardware Weld Broken/Damaged Part Incorrect Cracks Inspection Incomplete Wrong Stock Pulled Crushed/Crimped Instructions Incomplete/Unclear Part Lost/Missing Burrs Maintenance Part Moved Cuffs Contamination Positioned Wrong Countersink Mislabeled Heat Treat Power Loss/Surge Other Misread Inspection Strip in Tube Cut Too Short **Drill Holes** Offset Ripples in Bend Torque Waves in Extrusion Drawing Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

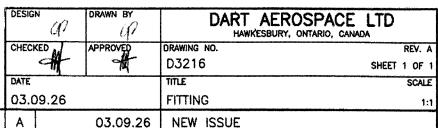
Wave/Twist in Tube

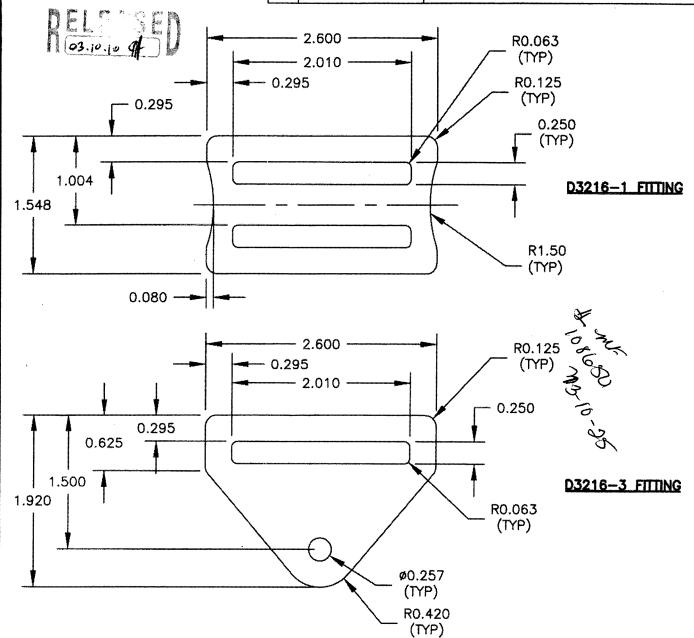
Finish

Folio

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D3216-1/-3 FITTING

- 1) MATERIAL: AISI 304/316 PLATE, 0.125 THICK (REF DART SPEC. M304S11GA)
- 2) FINISH: MOLECRO POLISH
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

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NCR: Y	es/	/ No				WORK ORDER NON-	·COľ	NFORM	MANCE / UP	DATE	QA Closed:	Date	2:
Work Order:						DISPOSITION AGAINST D				AGAINST DE	T DEPARTMENT/PROCESS		
Part No						Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite			Pro Rec/Sto	Engineering Quality Other	
Root					Descri	ption of work order update		nitial	Ac	tion	Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data							İ						
Equip/Tooling			-										
Operator													
Material													
Setup			Ì										
Other			1		i I								
Process													
Supplier							-		!				
Training					1		1	•					
Unapproved								-					
							FAUL	T CATE	GORY				
Landi	ng (Gear				General		_			_		
		Bending				Bend		Grain			Ovalized	L	Pressure/Forced
		Centre No	ot Conce	ntric to	o/s	BOM/Route		Hardwa	ire		Over/Under	tolerance	Temperature/Cure
Cracks			Broken/Damaged		Inspecti	ion Incomplete		Part Incorre	ct	Weld			
Crushed/Crimped			Burrs		Instruct	tions Incomplete/	Unclear	Part Lost/M	ssing	Wrong Stock Pulled			
Cuffs			Contamination]Mainte	enance		Part Moved	_				
		Heat Trea	at			Countersink		Mislabe	eled		Positioned V	Vrong	
		Inspectio	n Strip in	Tube		Cut Too Short		Misread	d		Power Loss/	Surge	Other
		Ripples ir	n Bend			Drill Holes		Offset		-			
Torque Waves in Extrusion			Drawing		Out of a	Calibration							

Out of Sequence

Outside Dimensions

Date:

Turning Sequence

Wave/Twist in Tube

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

DART AEROSPACE LTD	Work Order:	108600		
Description: Fitting	Part Number:	D3216-1		
Inspection Dwg: D3216 Rev: A		Page 1 of 1		

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	Prototype	
	Andrial		_

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.600	+/-0.010	2605	_		V	JAMOI
2.010	+/-0.010	2.016	_		V	
0.295	+/-0.010	0.294"			V	
1.548	+/-0.010	1.224)		V	
1.004	+/-0.010	F00.1)		V	
0.295	+/-0.010	0.296	-		V	
0.250	+/-0.010	0.253	_		V	
0.125	+/-0.010	0.116	J		V	
				!		
			DAS			

Measured by: Jm Audited by: 27 Prototype Approval: N/A

Date: 13-10-26 Date: 13 10 20 Date: N/A

Rev	Date	Change	Revised by Approved
Α	07.11.23	New Issue	KJ/EC/DD
			1,71

									DQA:	Date:	
NCR: Y	es / No				WORK ORDER NON-C	ONFORM	MANCE / UPI		QA Closed:	Date:	
Work Order:					DISPOSITION AGAINST DI				DEPARTMENT/PROCESS		
Part No					Rework Scrap Use-as-is Work Order Update	Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite			Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier		Engineering Quality Other
Root				Descri	ption of work order update	Initial	Act	ion	Sign &		
Cause	Date	Step	Qty	[,	or Non-conformance	Chief Eng	Descr	iption	Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling		1									
Operator											
Material				Ì							
Setup											
Other											
Process											
Supplier											

	FAULT CATEGORY									
Landing Gear		General		· ·		_				
[Bending	Bend		Grain		Ovalized	Pressure/Forced			
	Centre Not Concentric to O/S	BOM/Route		Hardware		Over/Under tolerance	Temperature/Cure			
	Cracks	Broken/Damaged		Inspection Incomplete		Part Incorrect	Weld			
	Crushed/Crimped	Burrs		Instructions Incomplete/Unclear		Part Lost/Missing	Wrong Stock Pulled			
	Cuffs	Contamination		Maintenance		Part Moved				
	Heat Treat	Countersink		Mislabeled		Positioned Wrong				
	Inspection Strip in Tube	Cut Too Short		Misread		Power Loss/Surge	Other			
Ripples in Bend Torque Waves in Extrusion Turning Sequence		Drill Holes Drawing Finish		Offset						
				Out of Calibration						
				Out of Sequence						
	Wave/Twist in Tube	Folio	Γ	Outside Dimensions						

Training Unapproved